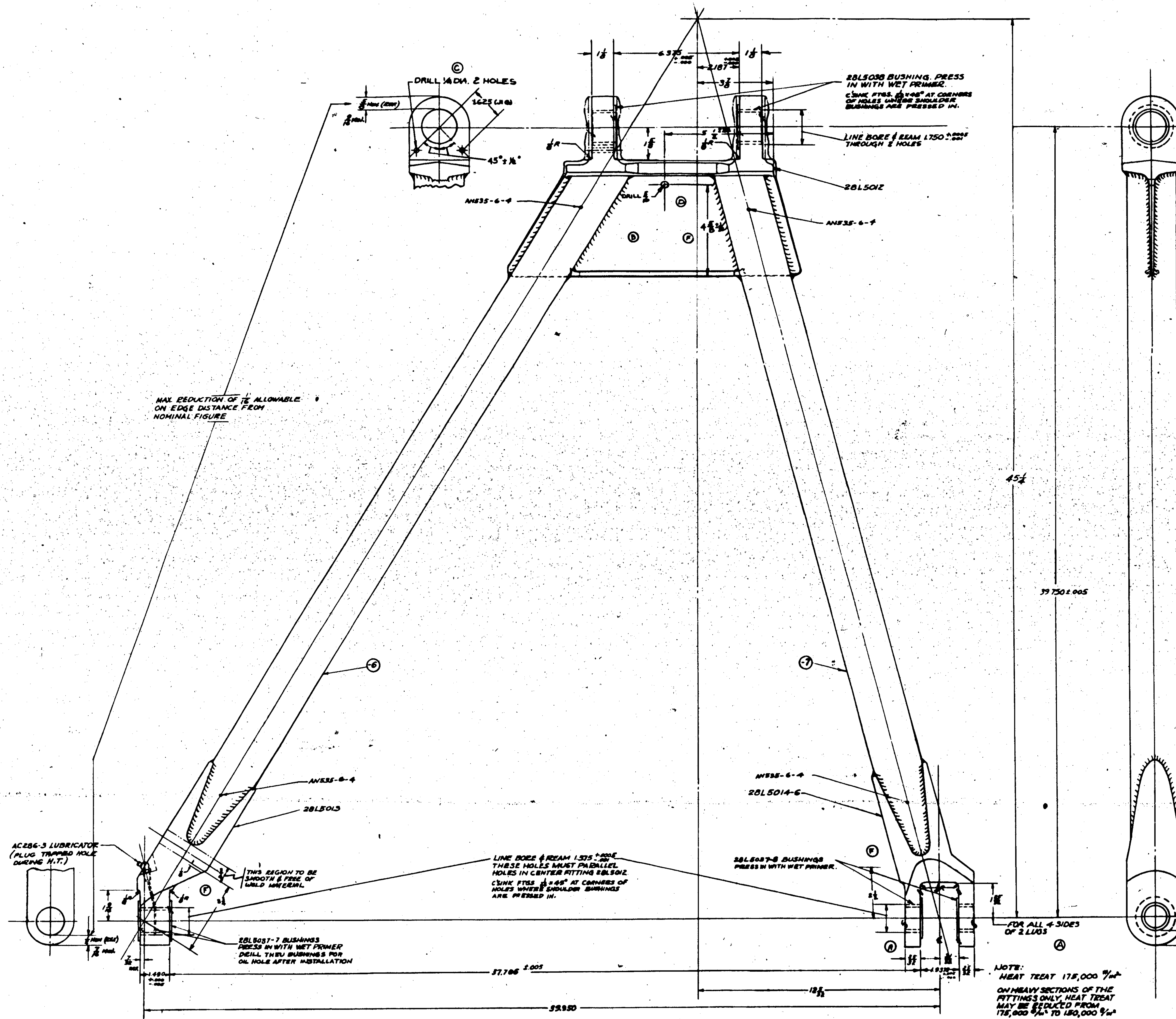


NOTE:
HEAT TREAT 175,000 #/in²

ON HEAVY SECTIONS OF THE FITTINGS ONLY, HEAT TREAT MAY BE REDUCED FROM 175,000 #/in² TO 150,000 #/in²

BREAK ALL SHARP CORNERS ON FTGS.

PLUG ALL TAPPED HOLES BEFORE HEAT TREAT

FINAL FINISH MACHINING AFTER H.T.

FINISH: OUTSIDE: C-P
INSIDE: DRILL & PLUG CLOSED TUBES FOR PARALKETONE OR EQUIVALENT.

-6 & -7 TUBES MAY BE GROUND DOWN TO 2 1/2 ± [illegible] O. DIA. TO PERMIT OVERSIZE TUBING TO GO INTO FITTINGS FOR A LENGTH OF APPROX. 5" BACK FROM ENDS OF TUBES.

EXTREME CARE SHOULD BE EXERCISED IN THE WELDING OPERATION ON FORGINGS OF HIGH-CARBON CONTENT IN ORDER TO ELIMINATE CRACKING.

FINISH CODE	
Z	ANODIC TREATMENT
P	P-27 PRIMER
AP	ALUMINIZED PRIMER
C	CADMIUM PLATE

LET	ALTERATION	DATE	BY	
A	[illegible]	[illegible]	[illegible]	E.A. 28736
B	[illegible] DRILL [illegible]	[illegible]	[illegible]	E.A. 31128
C	ADDED [illegible] DRILL HOLES (2) IN 28L5012-7. ALSO DIM. 1.625 & ANGLE 45° ± ½°. NO WT. CHG.	[illegible]	[illegible]	E.A. [illegible]
D	ADDED [illegible] DRILL HOLE & DIM. [illegible] NEG. WT. CHG.	[illegible]	[illegible]	E.A. [illegible]
E	ADDED NOTE "-6 & -7 TUBES MAY ---- ENDS OF TUBES" NO WT. CHG.	[illegible]	[illegible]	E.A. [illegible]
F	REMOVED 28L5078 (2) & [illegible] HOLE IN 28L5012. NEG. WT. CHG.	[illegible]	[illegible]	E.A. [illegible]

PART NO.	STOCK	MATERIAL	SPEC	REQ
AN535-6-4				4
AC286-3				1
28L5038				2
28L5037-8				2
28L5037-7				2
28L5014-6				1
28L5013				1
28L5012				1
28L5015-7	[illegible] × .156 × 37	[illegible] STL. TUBE	44T18	1
28L5015-6	[illegible] × .156 × 42	[illegible] STL. TUBE	44T18	1

PARTS LIST PER ASSY. — -0, -2, -3, -4, -5

MODEL	NEXT ASSY	
28-5AMN	[illegible]	2
30-5AMC	[illegible]	2
PBY-5A	[illegible]	2

REQUIREMENTS PER AIRPLANE

SUPERSEDES: 3749

SUPERSEDED BY

LIMITS ON DIMENSIONS UNLESS OTHERWISE SPECIFIED: ± .010

SCALE: 6" = 1'-0"

[redacted]

A C
NAVY HEAT TREAT: NOTED
FINISH: NOTED

DRAFT / CHECK / STRUCT / MAT / APPRVD

NAME: ASSEMBLY - M.L.G. LOWER VEE STRUT

CONSOLIDATED AIRCRAFT CORP. SAN DIEGO, CALIF.

J 28L5015

R

H 457